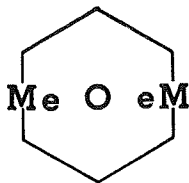


ORGANOCERAMS®
a division of HITCO



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March, 1973

P R O D U C T D A T A S H E E T

5-3008

PATCHING AND ADHESIVE COMPOUND
(Non-flowing)

DESCRIPTION AND USES

This compound is a carefully formulated thixotropic paste material designed for rapid room temperature cure, for repairing, filling and other structural adhesive uses. Outstanding features are excellent Skydrol 500 and water resistance, high shear strength and toughness over a wide temperature range (-60 - 250°F).

The 5-3008 compound comes in Types I and II. Although the ultimate physical and chemical properties are the same, there is some difference, primarily in handling. The following is a comparison of both:

GENERAL PROPERTIES

	<u>TYPE I</u>	<u>TYPE II</u>
Type	Modified Epoxy	Modified Epoxy
Viscosity	Stiff paste	Soft paste
Weight	12 ± .2 lb/gal when mixed	
Flow	None	None
Extrusion (gun)	Fair	Good
Pot Life (200 grams)	30 - 40 minutes	50 - 60 minutes
Hard Gel (77°F)	60 - 75 minutes	90 minutes
Cure thru (77°F) (sanding or drilling)	2 - 3 hours	3 hours

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CURED PROPERTIES*

		<u>Test Conditions</u>
Appearance	Metallic	
Hardness	70 - 80	Barcol
Heat Distortion	250°F	264 psi
Tensile Shear	1500 - 1800 psi	No primer, aluminum, 1200 - 1400 lb/minimum load
Tensile Shear	1500 - 1700 psi	After 30 days in Skydrol 500
Tensile Shear	1600 - 1800 psi	After 30 days in water
Tensile Shear	340 - 400 psi	At 300°F
Peel Adhesion	35 - 40 lb/inch	Climbing drum technique, room temperature
Tensile Strength	7000 - 8000 psi	Room temperature
Elongation	0 - 3%	
Impact	..25 ft-lbs	Izod

*24 hour air cure at 77°F followed by 30 minutes at 300°F.

DIRECTIONS FOR USE

1. Combine components A and B at equal proportions by volume. If weighing is desired, 15 parts A to 19 parts B by weight.
2. Apply immediately as the pot life is only 30 - 40 minutes on 200 gram quantities at 78°F.
3. A long pot life will be obtained by reducing component B by 10 - 20% by a sacrifice in curing speed and some peel adhesion.
4. Allow a 24 hour cure (78°F) before exposure to chemicals.
5. For maximum properties at elevated temperatures, cure for 30 - 60 minutes at 300°F.